

slip July 6

Work Order ID 85735

\*85735\*

June-14-12 1:55:18 PM

Item ID: D3915-041

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3915	C

100 Weld per dwg A/R Aluminum rod Batch: 120854  
Large Fab

\*100\*

Large Fab


Large Fab

Memo 0.00

1- assemble ribs , weld as per dwg D3915 using DT9606A. When welding D4019-3, weld top and bottom then make a small hole in the weld to let air out. Then weld remaining sides of D4019-3 Rib. Let it cool down, then block holes with weld.

\*\*\*\*DO NOT WELD THE (4) CORNERS. GRIND OFF CORNERS TO HAVE A 1/8" GAP TO GET THE ACID AND ALODINE OUT OF BASKET LID FRAME\*\*\*\*

2- weld hinge, label plate and Mounting plates as per dwg D3915

1x  6/12/06.22

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Quality Control

Memo 0.00

 12.06.22 

**Work Order ID 85735**

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**\*85735\***

Page 2

Item ID: D3915-041

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

M/PD 12-06-22

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

\*\*\*ENSURE TO RINSE CAREFULLY ACID AND ALODINE\*\*\*

L 12-6-26

140

Weld per dwg A/R Aluminum rod Batch: 11/20854 0.00

**\*140\***

Large Fab

Memo

0.00

Large Fab

1- weld (4) corners

CPL/CC 12-7-6

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/>            Other <input type="checkbox"/> </div> <div>           Engineering Quality <input type="checkbox"/>     <input type="checkbox"/>     <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Offset/Setup											
Other											
Process											
Supplier											
Training											
Unauthorized											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong  <b>Drill Holes</b> <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many	<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing	<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material	<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other _____ _____ _____

**Work Order ID 85735**

June-14-12 1:55:18 PM

**\*85735\***

Page 3

Item ID: D3915-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
155	QC6- Inspect dimensions to drawing	0.00							
<b>*155*</b>									
QC	Memo	0.00							
Quality Control									
	***inspect fit of lid with base***								
157	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*157*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1- realodine corners								
	***do not acid etch***								

**Work Order ID 85735****\*85735\***

Page 4

June-14-12 1:55:18 PM

Item ID: D3915-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*160\***

Powdercoat

Powder Coating

Memo

0.00

1- touch up corner with alodine only  
2- Plug holes prior to

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

170

QC3- Inspect Part Finish

0.00

**\*170\***

QC

Quality Control

Memo

0.00

M121481

12-45  
3200FX / M.F.  
12/07/10

1 / 12-7-10

**Work Order ID 85735**

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**\*85735\***

Page 5

Item ID: D3915-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Assemble as per dwg	0.00							
<b>*180*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1- Install webbing as per dwg								
	2- Install placard and label as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									
200	Identify as per dwg & Stock Location	0.00							
<b>*200*</b>									
Packaging	Memo	0.00							
Packaging									

1  $\phi$  BR 12-7-11

8/10/11

85732

1  $\phi$  BR 12-7-11

**Work Order ID 85735****\*85735\***

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Item ID: D3915-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									

MC5 12/07/11  
MC5 12/07/11

# Picklist Print

June-14-12 1:55:23 PM

Page 1

Work Order ID: 85735

\*85735\*

Parent Item: D3915-041

\*D3915-041\*

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C add realodine DD 10.04.26 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2957		Manufactured	No			100	Each	18.0000	4	4			
*D2957*									**			CC 17.6-22	
Mounting Plate													

Location Loc Qty Loc Code

WA 10

84820 10

WA005 8

82668 8

D3915-1		Manufactured	No			100	Each	0.0000	2	2			
*D3915-1*									**			383844 → ③ 17.6-22	
Rib													

D4016-5		Manufactured	No			100	Each	6.0000	3	3			
*D4016-5*									**			CC 17.6-22	
Hinge Half, Light Lid													

Location Loc Qty Loc Code

WA 6

84821 6

D4019-3		Manufactured	No			100	Each	5.0000	3	3			
*D4019-3*									**			CC 17.6-22	
Rib													

Location Loc Qty Loc Code

WA 5

63667 0

83798 5





# Picklist Print

June-14-12 1:55:23 PM

Page 2

Work Order ID: 85735

**\*85735\***

Parent Item: D3915-041

**\*D3915-041\***

Parent Item Name: Light Lid Assembly, Long Basket

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4035-045

Manufactured No

100

Each

7.0000

1

1

**\*D4035-045\***

Lid Rib Assembly, Fwd (Light)

\*\*

*Cpl 12-06-21*

Location

Loc Qty

Loc Code

WA

7

63668

0

74466

3

84688

4

①

D4035-047

Manufactured No

100

Each

2.0000

1

1

**\*D4035-047\***

Lid Rib Assembly, Aft (Light)

\*\*

*CC 12-6-22*

Location

Loc Qty

Loc Code

WA006

2

74809

2

①

D4056-1

Manufactured No

100

Each

4.0000

1

1

**\*D4056-1\***

Label Plate

\*\*

*CC 12-6-22*

Location

Loc Qty

Loc Code

WA

2

84140

2

①

WA005

2

84866

2

D2728-1

Manufactured No

180

Each

0.0000

1

1

**\*D2728-1\***

Dart Logo label

\*\*

*~~CC 12-6-22~~*



June-14-12 1:55:24 PM

Shop Packet Print

Page 2

### WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:                      Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev F

# Picklist Print

June-14-12 1:55:24 PM

Page 3

Work Order ID: 85735

Parent Item: D3915-041

Parent Item Name: Light Lid Assembly, Long Basket

\*85735\*

\*D3915-041\*

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4029-041

Manufactured No

180

Each

9.0000

1

\*D4029-041\*

Webbing (Long Basket)

\*\*

## Location

## Loc Qty

## Loc Code

st503

9

83655

4

84417

5

MS20600-AD4W3

Purchased

No

180

Each

740.0000

34

\*MS20600-AD4W3\*

Cherry Rivets

\*\*

## Location

## Loc Qty

## Loc Code

ST321

607

111636

36

117601

3

118626

310

120308

258

WA018

133

107939

133

NAS1149DN416J

Purchased

No

180

Each

113.0000

34

\*NAS1149DN416.I\*

Washer

\*\*

## Location

## Loc Qty

## Loc Code

ST297

113

114597

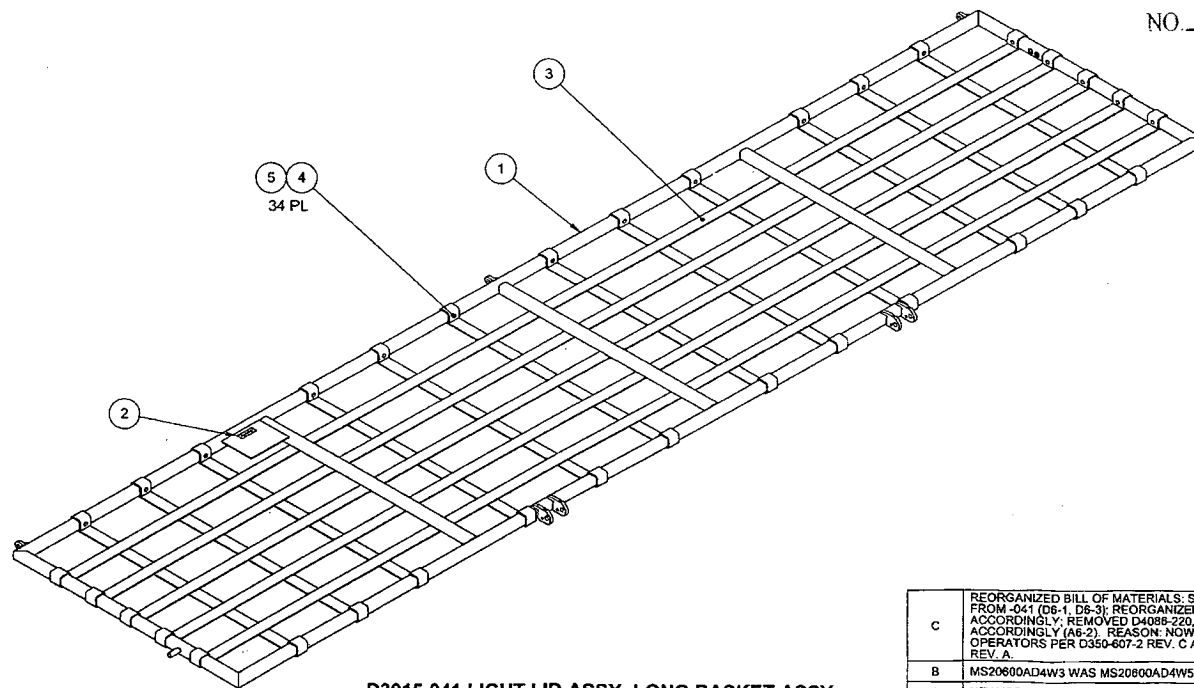
43

13910

70

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3915-041	LIGHT LID ASSY, LONG BASKET ASSY
1	1	D3915-101	BASKET LID WELDMENT ASSY
2	1	D2728-1	DART LOGO LABEL
3	1	D4029-041	WEBBING (LONG BASKET)
4	34	MS20600AD4W3	BLIND RIVET
5	34	NAS1149DN416J	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85735 MLJ  
12/06/14



**D3915-041 LIGHT LID ASSY, LONG BASKET ASSY**

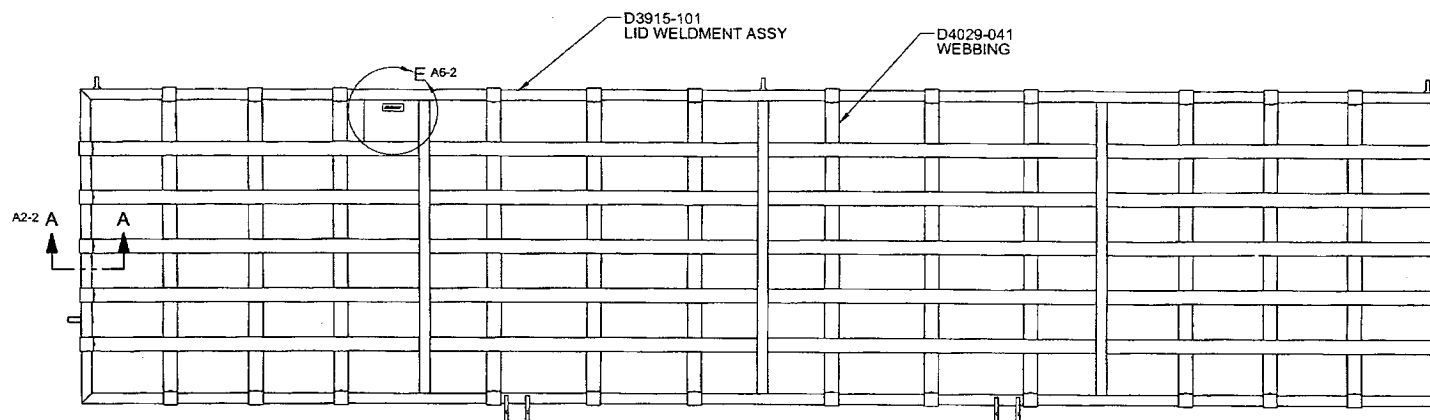
RELEASED  
10.08.12  
ECN 10-546

**NOTES:**

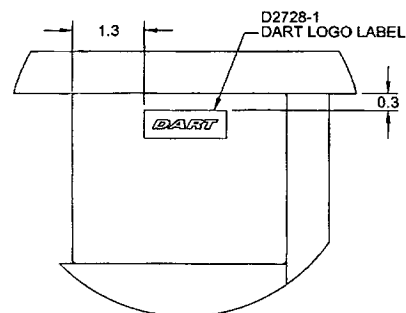
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.91 lbs

C	REORGANIZED BILL OF MATERIALS: SEPARATED -101 FROM -041 (D8-1, D8-3); REORGANIZED VIEWS ON SHT 3 ACCORDINGLY; REMOVED D4086-220, UPDATED VIEW E ACCORDINGLY (A6-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	MS20600AD4W3 WAS MS20600AD4W5: BOM & (B1-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LIGHT LID ASSY-LONG BASKET	INTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

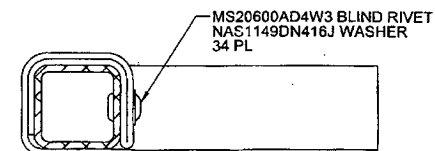
85735



**D3915-041 LIGHT LID ASSY, LONG BASKET**



**VIEW E** D6-2

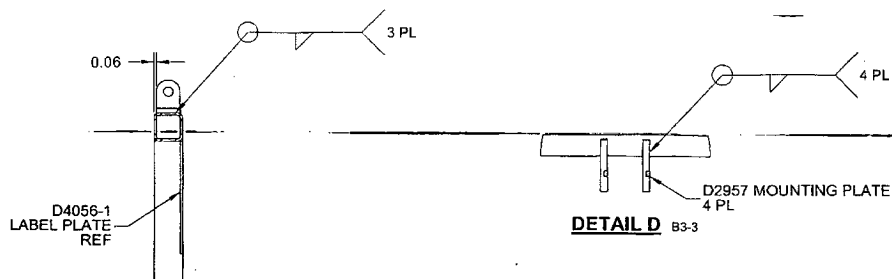


**SECTION A-A** C8-2

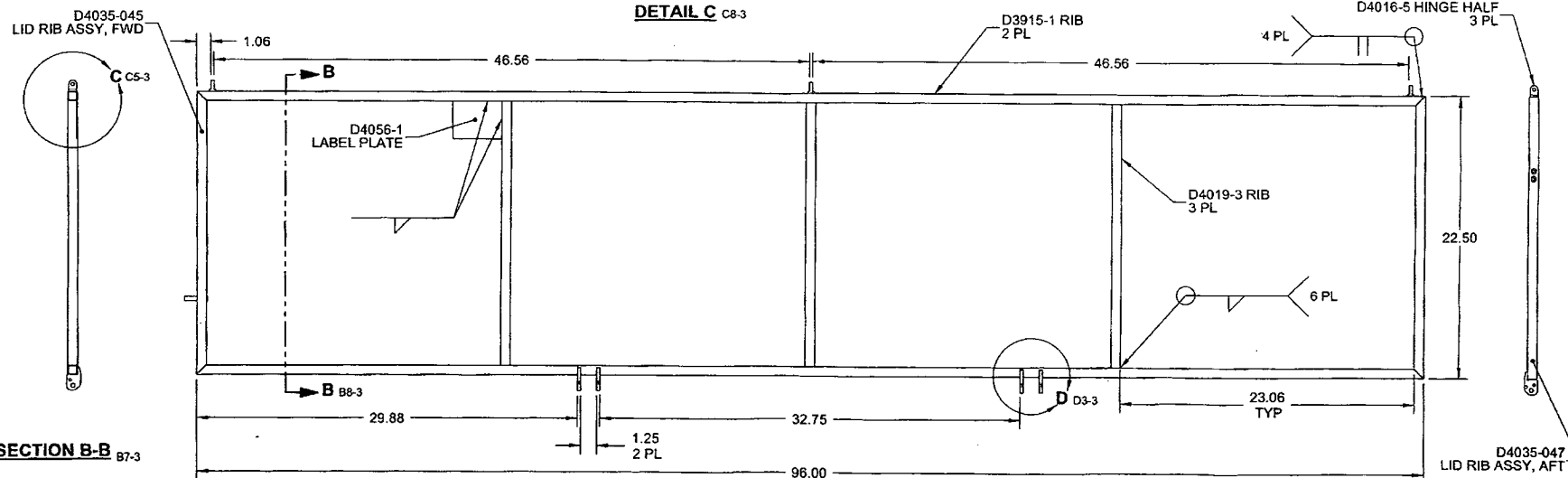
**RELEASED**  
19-08-12

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	ALS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	ALS	D3915	SHEET 2 OF 4
APPROVED	ALS	TITLE	SCALE
DE APPR.	ALS	<b>LIGHT LID ASSY-LONG BASKE</b>	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3915-101	BASKET LID WELDMENT ASSY
1	4	D2957	MOUNTING PLATE
2	2	D3915-1	RIB
3	3	D4016-5	HINGE HALF, LIGHT LID
4	3	D4019-3	RIB
5	1	D4035-045	BASKET LID RIB ASSY, FWD (LIGHT)
6	1	D4035-047	BASKET LID RIB ASSY, AFT (LIGHT)
7	1	D4056-1	LABEL PLATE, 350 LIGHT BASKET



85735



**D3915-101 BASKET LID WELDMENT ASSY**

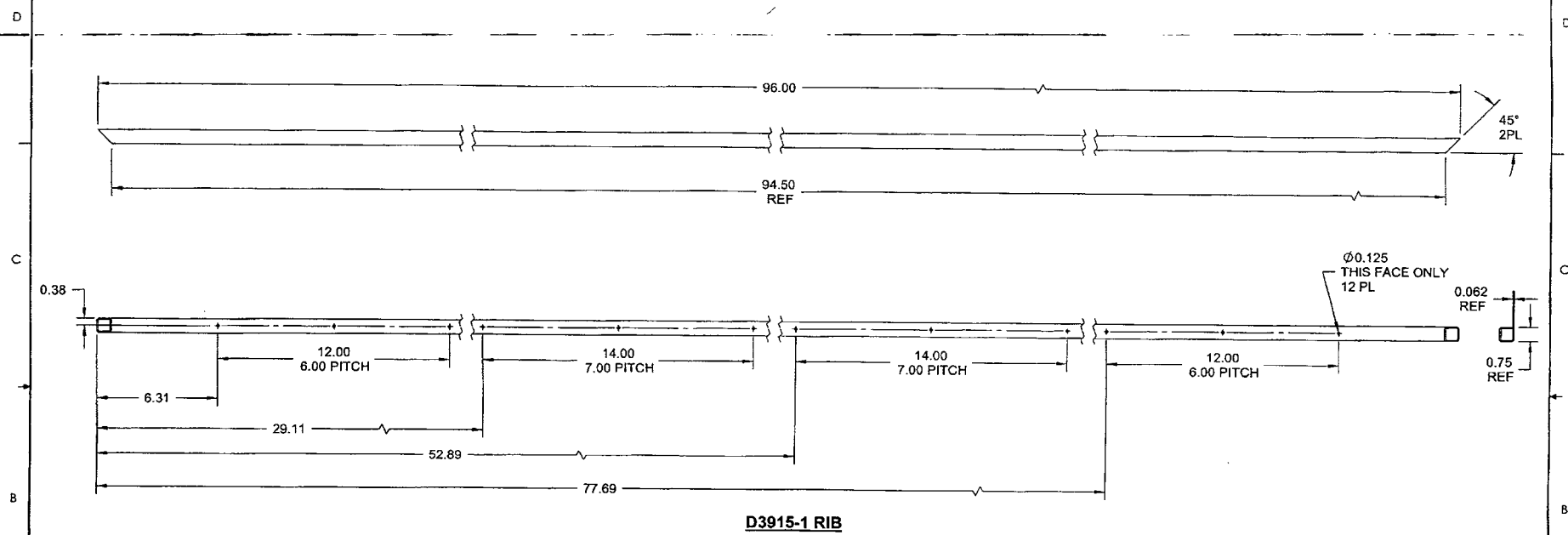
**RELEASED**  
10.08.05

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.81 lbs
- 8) WELD PER DART QSI 004

DESIGN	115	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3915	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>LIGHT LID ASSY-LONG BASKET</b>	<b>INTS</b>
DATE	10.08.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

85735



**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4115 / 4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC. M6061T6TS0.750W.062
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.49 lbs

**RELEASED**  
10.01.12

DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. <b>D3915</b>	REV. C SHEET 4 OF 4
CHECKED	MP	TITLE <b>LIGHT LID ASSY-LONG BASKET</b>	SCALE <b>NTS</b>
MFG. APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
APPROVED		DATE <b>10.08.05</b>	
DE APPR.			